

# Work Order ID 52895

October 19, 2009 10:38:28 AM



Page 1

Item ID: D3177-043

Accept



Setup Start



Revision ID: B2

Stop



Item Name: Bracket

Start Date: 10/19/09 Start Qty: 3.00



Cust Item ID:

Required Date: 10/27/09 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: 09-10-10 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3177	Rev B2

100

0.00



BAND SAW

Bandsaw

Memo

0.00

*only 09/10/27*

*3*

Jeaspa Bandsaw

Cut blank: 47.40" x (12.000" +0.100/-0.000)

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine part as per Folio FA291 and Dwg D3177.1 IDeburr

*DIT 09/10/27*  
*M.A 09/10/28*

*3*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*DIT 09/10/28*

*3*

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Item ID: D3177-043

Accept

Revision ID: B2

Item Name: Bracket

Start Date: 10/19/09 Start Qty: 3.00

Required Date: 10/27/09 Req'd Qty: 3.00




Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	mk 09/10/30			3	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	MD 09/11/02			x3			
150  Small Fab Small Fab	Small Fab  Memo Press D3177-5 Spacers as shown on Dwg D3177	0.00  0.00	7m-k 09/11/02			(3x)			



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Item ID: D3177-043

Accept

Revision ID: B2

Item Name: Bracket

Start Date: 10/19/09 Start Qty: 3.00

Required Date: 10/27/09 Req'd Qty: 3.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	802104			3	1		
200  Packaging Packaging	Identify as per dwg & Stock Location <u>200</u>  Memo	0.00  0.00				9/11/06	3	SP	
210  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				09/11/06 ME 09-10-05			

# Picklist Print

October 19, 2009 10:38:32 AM

Work Order ID: 52895

Parent Item: D3177-043RevB2

Parent Item Name: Bracket

Comments:

Start Date: 10/19/09

Required Date: 10/27/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-11		Purchased	No			100	Each	95.0000	3.0000			



Screw

*EP 09/11/04*

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

95

9662

95

M6061T6B1.000X12.00

Purchased

No

150

f

19.1000

12.4999

3

0



6061-T6 Bar 1.00 x 12.00



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

19.1

104719

2.5

106701

16.6

*6.2397, 09/10/27*

# Picklist Print

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Page 2

Work Order ID: 52895

Parent Item: D3177-043RevB2

Parent Item Name: Bracket



Comments:

Start Date: 10/19/09

Required Date: 10/27/09

Start Qty: 3.00



Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10  Washer		Purchased	No			180	Each	1,920.000	9.0000		<i>EP 09/11/04</i>	

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	1920
105442	95
109059	2
109840	23
110985	202
111279	5
111668	64
112314	1000
112369	529

BLRS-010  Pip Pin		Purchased	No			180	Each	32.0000	3.0000		<i>EP 09/11/04</i>	
---	--	-----------	----	--	--	-----	------	---------	--------	--	--------------------	--

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	32
112478	2
112689	30

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Shop Packet Print

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# Picklist Print

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Work Order ID: 52895

Parent Item: D3177-043RevB2

Parent Item Name: Bracket


Comments:

Start Date: 10/19/09

Required Date: 10/27/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2690-6RevB2		Manufactured	No			180	Each	32.0000	3.0000			
												
Lanyard Assembly												

*9509/11/04*

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

2

44048

2

Main Warehouse

ST41

30

50665

30

D3177-5RevB2

Manufactured

No

180

Each

53.0000

12.0000



Spacer

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

53

20295

53 ✓

*20295*  
*M.H 09/11/02*

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Shop Packet Print

Page 3

# Picklist Print

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Page 4

Work Order ID: 52895

Parent Item: D3177-043RevB2

Parent Item Name: Bracket

Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			180	Each	3,493.000	3.0000			



Nut



*GP 10/11/04*

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

3493

110844

32

111274

41

111668

920

112314

2000

112385

500

\_\_\_\_\_  
\_\_\_\_\_  
*3*  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

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Shop Packet Print

Page 4



D3065-5DART AEROSPACE LTD		Work Order:	52895
Description: Bracket		Part Number:	D3177-3
Inspection Dwg: D3177	Rev: B2	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.970	+0.010/-0.000	0.980	✓			
R0.125	+/-0.010	0.125	✓			
0.700	+0.010/-0.000	0.700	✓			
0.188	+0.010/-0.000	0.189	✓			
10.776	+/-0.005	10.776	✓			
R0.625	+/-0.010	0.625	✓			
Ø0.261	+0.005/-0.000	0.263	✓			
0.200	+/-0.010	0.199	✓			
Ø0.203	+0.005/-0.000	0.203	✓			
Ø0.625	+0.001/-0.000	0.626	✓			
3.733	+0.000/-0.005	3.733	✓			
0.575	+/-0.010	0.570	✓			
0.700	+0.010/-0.000	0.700	✓			
0.970	+0.010/-0.000	0.980	✓			

Measured by: DJP	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/10/28	Date: 09/10/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF [Signature]	[Signature]

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[illegible]

1) MACHINE D3177-1 PER DART DWG "D3177-1.SLDPRT"  
MATERIAL: 6061-T6 ALUMINUM BAR (QQ-A-250/11 OR QQ-A-200/8)  
(REF DART SPEC. M6061T6S OR M6061T6B)

2) BREAK ALL SHARP EDGES 0.005 TO 0.015

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (PRIOR TO ASSEMBLY)  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 (AFTER ASSEMBLY)

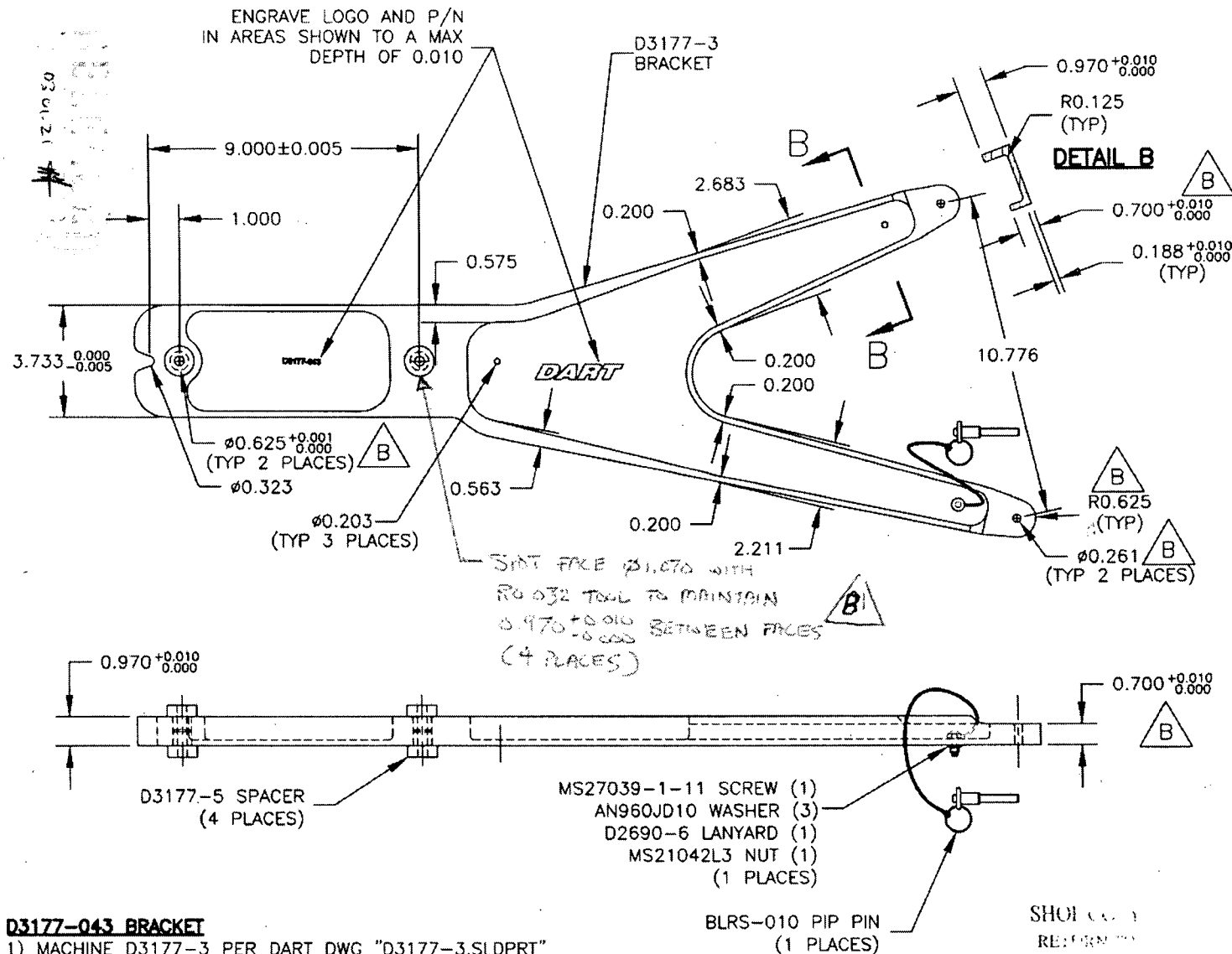
4) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32895

**DART**

PL 09-10-10



# **D3177-043 BRACKET**

- 1) MACHINE D3177-3 PER DART DWG "D3177-3.SLDPRT"  
MATERIAL: 6061-T6 ALUMINUM BAR (QQ-A-250/11 OR QQ-A-200/8)  
(REF DART SPEC. M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4:1 (PRIOR TO ASSEMBLY)  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 (AFTER ASSEMBLY)
- 4) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

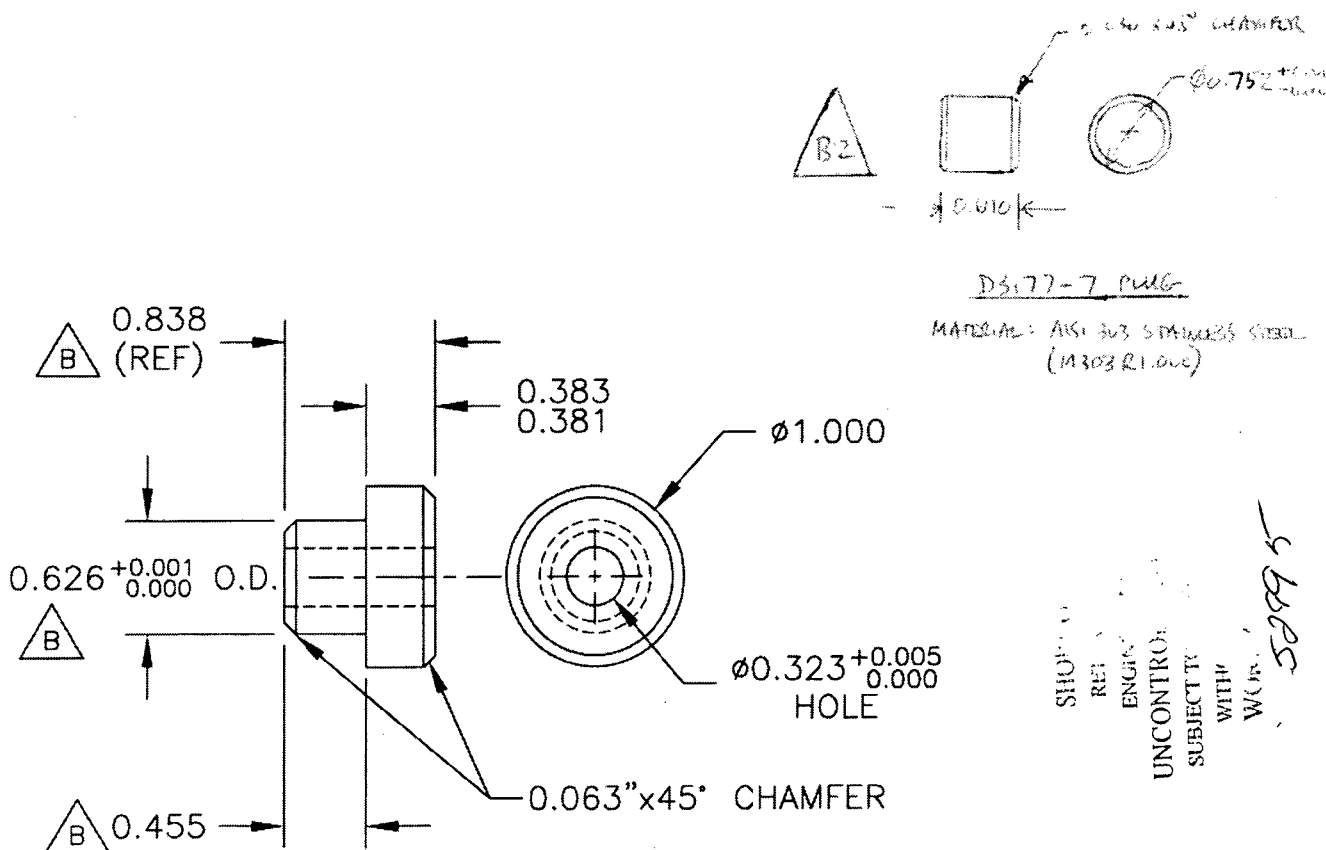
SHO...  
REFORM...  
ENGINE...  
UNCONTROL...  
SUBJECT TO...  
WITHOUT...  
WORK...  
NO. 52995



DESIGN	DRAWN BY	DART Aerospace LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
03.01.07	D3177	SHEET 2 OF 3
	TITLE	SCALE
	BRACKET	1:5



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3177	REV. B SHEET 3 OF 3
DATE 03.01.07		TITLE BRACKET	SCALE 1:1



### D3177-5

- 1) MATERIAL: 6061-T6 ALUMINUM BAR  $\phi 1.000$   
(QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6R1.000)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

03.01.21 *[Signature]*

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